

2B•2 Engine removal and overhaul procedures

Piston and connecting rod (continued)

Piston-to-bore clearance	0.010 to 0.030 mm
Piston gudgeon pin bore diameter	18.004 to 18.010 mm
Gudgeon pin outer diameter	17.994 to 18.000 mm
Piston-to-gudgeon pin clearance	0.004 to 0.016 mm
Connecting rod small-end bush diameter	17.962 to 17.978 mm
Connecting rod small-end bush-to-gudgeon pin clearance	-0.016 to -0.038 mm (ie an interference fit)
Connecting rod big-end bore diameter	43.000 to 43.013 mm
Connecting rod big-end bearing side clearance:	
Standard	0.20 to 0.47 mm
Service limit	0.55 mm

Crankshaft

Endfloat:	
Standard	0.060 to 0.26 mm
Service limit	0.3 mm
Run-out:	
Standard	Less than 0.05 mm
Main bearing journal diameter:	
Grade 0	44.966 to 44.970 mm
Grade 1	44.962 to 44.966 mm
Grade 2	44.958 to 44.962 mm
Grade 3	44.954 to 44.958 mm
Main bearing journal ovality	Less than 0.005 mm
Main bearing journal taper	Less than 0.002 mm
Big-end bearing journal diameter	39.96 to 39.97 mm
Big-end journal ovality	Less than 0.005 mm
Big-end journal taper	Less than 0.002 mm
Main bearing running clearance:	
Standard	0.022 to 0.038 mm
Service limit	0.064 mm
Big-end bearing running clearance:	
Standard	0.010 to 0.044 mm
Service limit	0.064 mm
Main bearing shell thicknesses:	
Standard:	
Black	2.000 to 2.004 mm
Brown	2.002 to 2.006 mm
Green	2.004 to 2.008 mm
Yellow	2.006 to 2.010 mm
Blue	2.008 to 2.012 mm
Pink	2.010 to 2.014 mm
White	2.012 to 2.016 mm
0.25 mm undersize	2.125 to 2.129 mm
Big-end bearing shell thicknesses:	
Standard	1.504 to 1.508 mm
Undersize	1.629 to 1.633 mm

Piston rings

Ring-to-groove clearance:	
Standard:	
Top compression ring	0.50 to 0.73 mm
Second compression ring	0.030 to 0.070 mm
Service limit	0.2 mm
End gaps:	
Standard:	
Top compression ring	0.20 to 0.30 mm
Second compression ring	0.30 to 0.45 mm
Oil control ring	0.25 to 1.00 mm
Service limit:	
Top compression ring	0.37 mm
Second compression ring	0.54 mm
Oil control ring	1.09 mm

Torque wrench settings

Refer to Chapter 2A Specifications.